

Work Order ID 65047

Thursday, January 06, 2011 10:36:48 AM

Page 1

Item ID: D2274

Accept

Revision ID:

Item Name: Radius Block

Start Date: 1/5/2011 Start Qty: 200.00

Required Date: 1/14/2011 Req'd Qty: 200.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 1-01-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2274

Rev F

100

0.00



SHEAR

Shear

Memo

0.00

Shear

blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces

0.00

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio D2274

0.00

120



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control



200

200

SL 1/10/11

SL 1/10/11






SL 1/10/11

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Item ID: D2274 Accept  Setup Start 
Revision ID: Stop 
Item Name: Radius Block
Start Date: 1/5/2011 Start Qty: 200.00  Cust Item ID:
Required Date: 1/14/2011 Req'd Qty: 200.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>SAO 11/01/11</i>		<u>200</u> <i>Ø</i>			
140  Small Fab Small Fab	Small Fab Memo Tumble <input type="checkbox"/> Deburr any rough edges after tumbling	0.00 0.00		<i>SAD 11-01-17</i>		<u>200</u> <i>certified</i>			
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		<i>=> M 11/01/18</i>		<u>200</u> <i>Ø</i>			

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Item ID: D2274

Accept

Revision ID:

Item Name: Radius Block

Start Date: 1/5/2011 Start Qty: 200.00

Required Date: 1/14/2011 Req'd Qty: 200.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

200 *pf* 11-01-18

170

Identify as per dwg & Stock Location: 10

0.00



Packaging

Memo

0.00

Packaging

11/1/18 *Rowe*

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/18 *MF**MF*

11-01-18

Picklist Print

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Work Order ID: 65047

Parent Item: D2274

Parent Item Name: Radius Block



Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP H□00.05.18□Added inspection level 8□EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No			100	f	99.0243	0.0916	19.28421			



6061-T6 Bar .750 x .125

Location	Loc Qty	Loc Code
MAT	80	
116406	80	
MAT01	19.0243	
113608	14.75	
113680	1.4947	
113719	2.7796	

19.3

smk 1/6/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

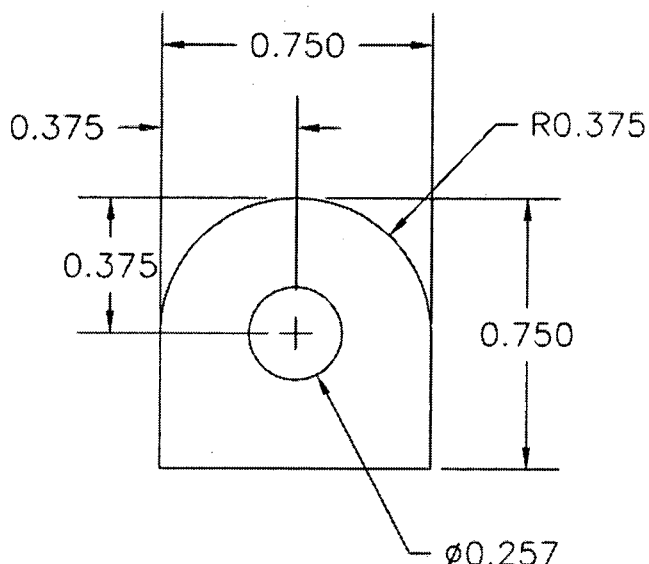
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>mm</i>	APPROVED <i>KS</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/13 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65047

pl 10-01-4

00.05.16
00.05.16

0.063 x 45° CHAMFER
~~R0.0 - 0.13~~

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries